

# Work Order ID 83490

April-18-12 2:45:31 PM

**\*83490\***

Page 1

Item ID: D2665-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop

**\*NS2\***

Start Date: 18/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/19

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2665	Rev D								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*100*</b>									
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	Program batch number.1- Inspect part number and batch number are programmed correctly.2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet								
110	CONVENTIONAL MILLING MACHINE	0.00							
<b>*110*</b>									
Mill Conv	<b>Memo</b>	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

*F.K 12/07/03*

*6*

*F.K 12/07/03*

*6*

*F.K 12/07/03*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83490**

April-18-12 2:45:31 PM

**\*83490\***

Page 2

Item ID: D2665-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

2L 12-07-04

**\*130\***

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

6x  $\phi$  12/07/05

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

9-20

6x  $\phi$  12/07/05

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83490**

April-18-12 2:45:31 PM

**\*83490\***

Page 3

Item ID: D2665-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop **\*NS2\***

Start Date: 18/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

X6 12/07/05

170

Identify as per dwg &amp; Stock Location: 438

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

(6x) 12-7-10 SP

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CK 12/7/11

MF 12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-18-12 2:45:34 PM

Page 1

Work Order ID: 83490

\*83490\*

Parent Item: D2665-1

\*D2665-1\*

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	71.0000	1	6			

\*D6101-003\*

Saddle Billet, 7075

\*\*

Location	Loc Qty	Loc Code
MAT040	26	
73775	2	
73780	7	
78599	10	
80765	0	
MAT041	1	
80765	1	
MAT042	43	
81924	50	
MAT044	1	
73769	1	

85434

6

F.K. 12/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 83490	
<b>Description:</b> 206 Saddle, Outboard, Left side				<b>Part Number:</b> D2665-1	
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.121	.120	.120	.120
B	0.100	0.140		.105	.106	.106	.106	.106
C	1.125	1.145		1.127	1.135	1.133	1.134	1.135
D	0.615	0.685		.645	.645	.645	.645	.645
E	0.240	0.260		.260	.254	.254	.254	.254
F	1.313	1.343		1.323	1.327	1.328	1.327	1.327
G	0.210	0.230		.216	.224	.225	.225	.225
H	0.100	0.180		.135	.135	.135	.135	.135
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.565	1.585		1.567	1.574	1.573	1.574	1.574
K	0.235	0.240		.238	.237	.238	.238	.238
L	0.100	0.120		.113	.112	.113	.113	.113
M	0.990	1.010		1.003	1.003	1.003	1.003	1.003
N	0.510	0.515		.512	.512	.512	.512	.512
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.314	.314	.314	.314	.314
S	0.315	0.322		.317	.317	.317	.317	.317
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.797	.795	.795	.797	.797
W	0.540	0.560		.550	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.912	0.932		.923	.924	.924	.924	.924
AA	0.490	0.510		.498	.500	.500	.500	.500
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> FK	<b>Date:</b> 12/07/03
<b>Audited by:</b> SL	<b>Date:</b> 12-07-04
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 83490
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

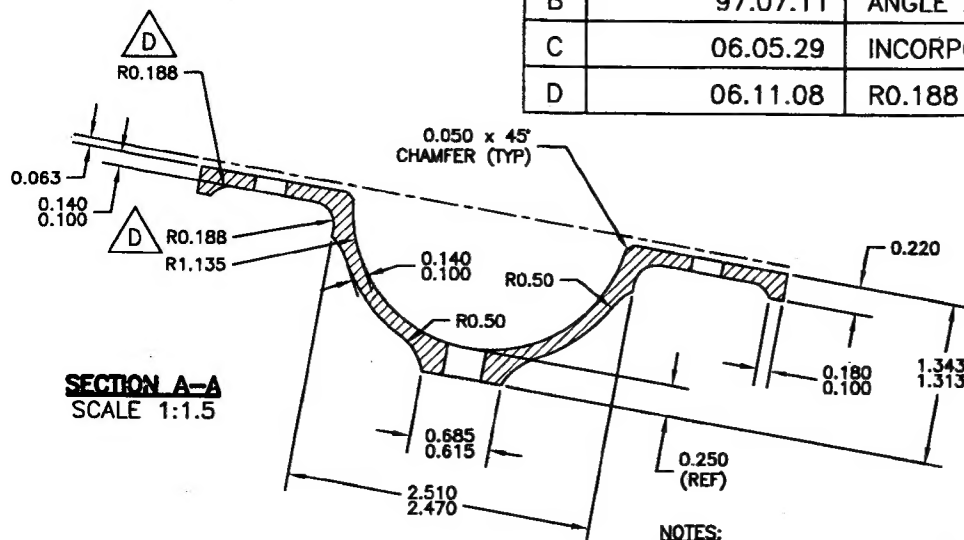
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	2	3	4	5
A	0.100	0.140		.120				
B	0.100	0.140		.106				
C	1.125	1.145		1.135				
D	0.615	0.685		.675				
E	0.240	0.260		.254				
F	1.313	1.343		1.327				
G	0.210	0.230		.225				
H	0.100	0.180		.135				
I	2.470	2.510		2.492				
J	1.565	1.585	1.574	1.569				
K	0.235	0.240		.238				
L	0.100	0.120		.113				
M	0.990	1.010		1.003				
N	0.510	0.515		.512				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.312	0.318		.314				
S	0.315	0.322		.317				
T	2.495	2.505		2.500				
U	1.357	1.367		1.362				
V	0.787	0.807		.797				
W	0.540	0.560		.550				
X	1.674	1.684		1.679				
Y	0.256	0.262		.258				
Z	0.912	0.932		.924				
AA	0.490	0.510		.497				
AB	0.178	0.198		.188				
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> Fk.	<b>Date:</b> 12/07/04
<b>Audited by:</b> SL	<b>Date:</b> 12-07-04
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	



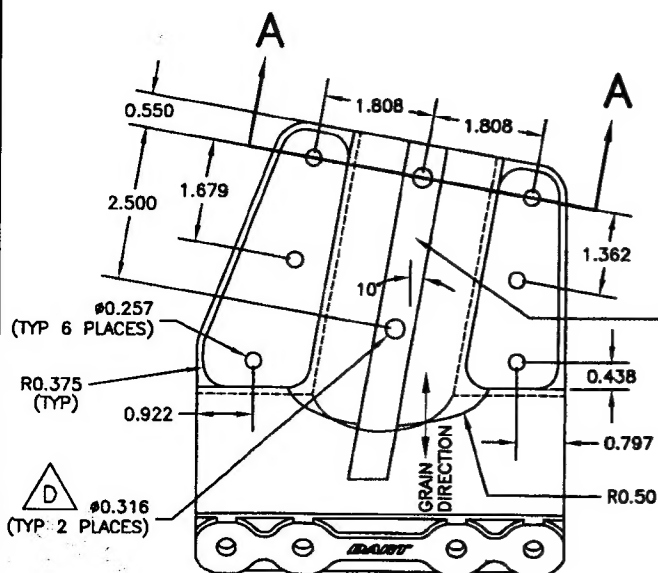
DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CB</i>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



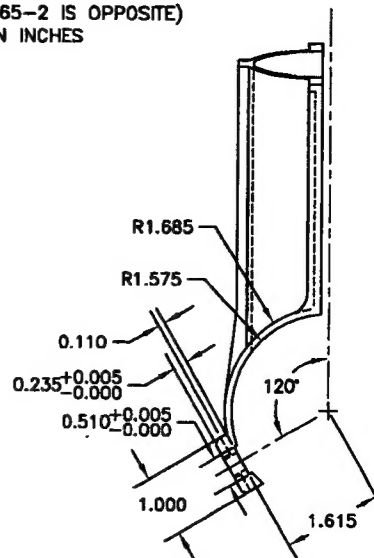
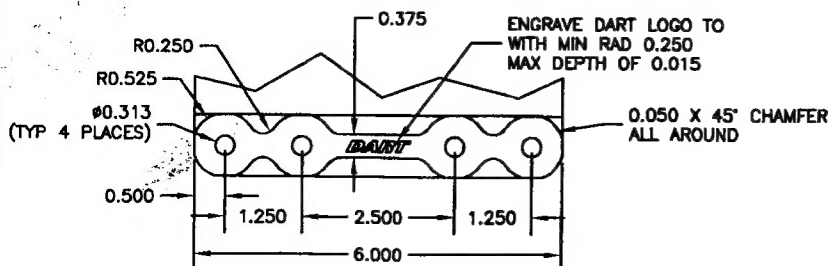
SECTION A-A  
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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07-02-12

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ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83490 M/S  
12/07/19

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